














Date: Tuesday, 9/4/2007 11:30:05 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE SHAFT
Job Number	: 34410		
Estimate Number	: 12170		
P.O. Number	: N/A	Part Number	: D34703
This Issue	: 9/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3470 REV.A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26115	Drawing Revision	: A
		Material	: N/A
		Due Date	: 10/4/2007
Written By	:	Qty:	6
Checked & Approved By	: <u>Am 09 04</u>	Um:	Each
Comment	: est rev A 06.04.20 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S13GA	304/316 .090" Sheet	
			
Comment: Qty.: 0.0079 sf(s)/Unit Total : 0.0473 sf(s) 304/316 .090" Sheet <u>M103033</u> <u>B 07-09-11</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET Cut as per Dwg D <u>B 07-09-11</u> <u>(8)</u> Dwg Rev: <u>A</u> Prog Rev: <u>A</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 07-09-11</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>Er 02/09/11</u> <u>(x8)</u> <u>counts</u>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>SAD 02/09/16</u> <u>(8)</u>			
6.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>Er 02/09/17</u> <u>(x8)</u> <u>counts</u>			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 9/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 34410

Part Number: D34703

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/09/17 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/18 (8)

Job Completion



CP 07/09/17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

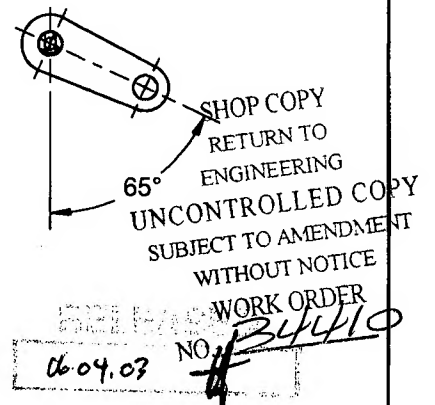
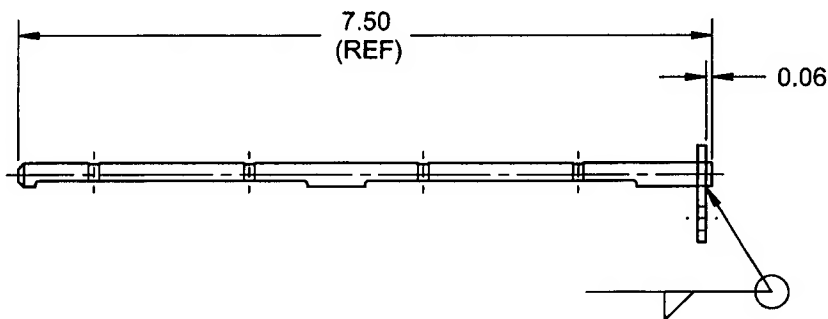
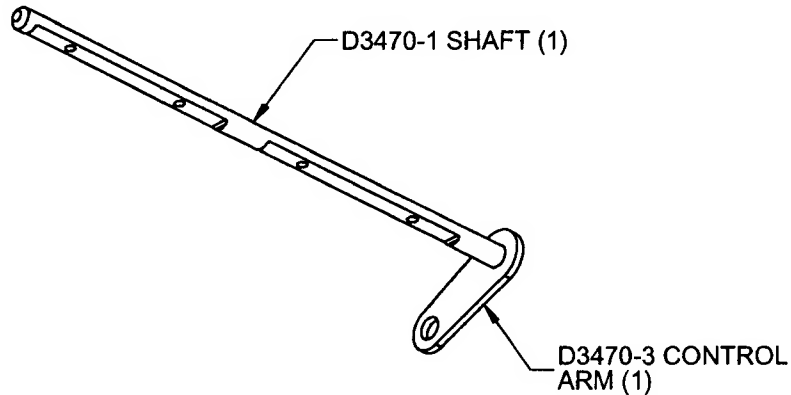
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3470	REV. A SHEET 1 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2
A	05.12.14	NEW ISSUE	

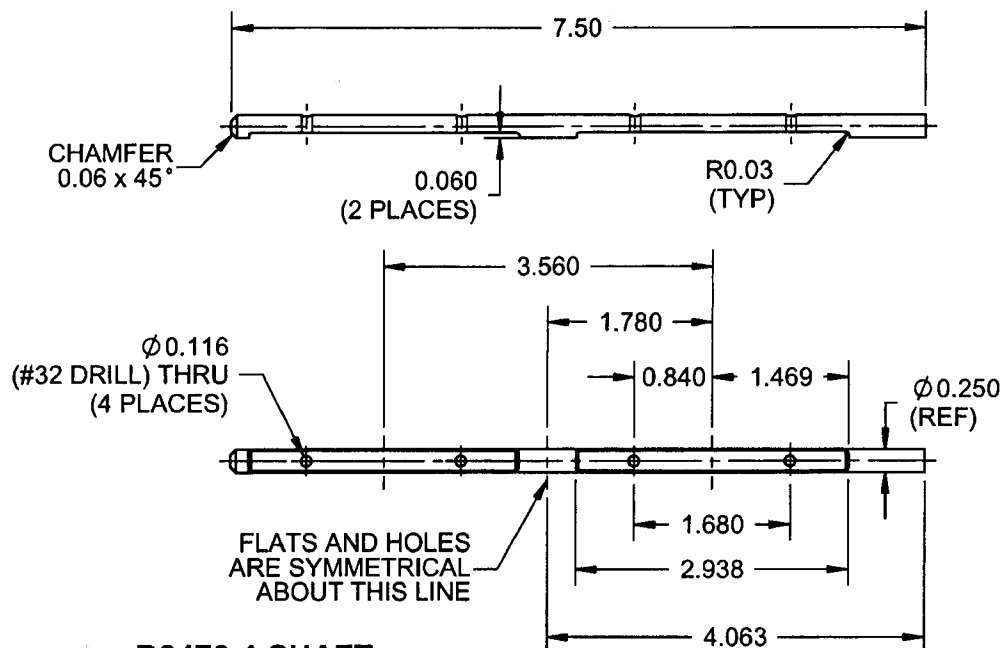
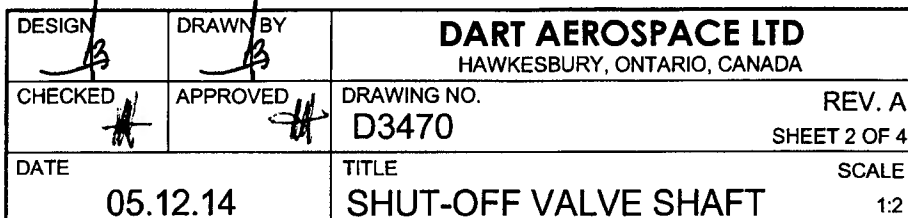
**D3470-041 SHUT-OFF VALVE SHAFT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

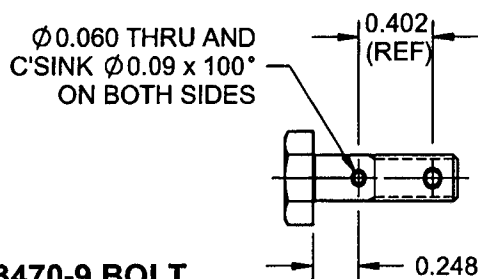
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)



D3470-9 BOLT
SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

06.04.03
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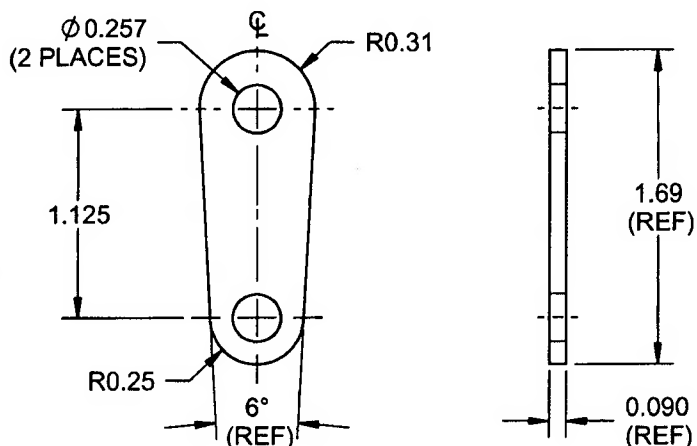
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	
			SCALE 1:1

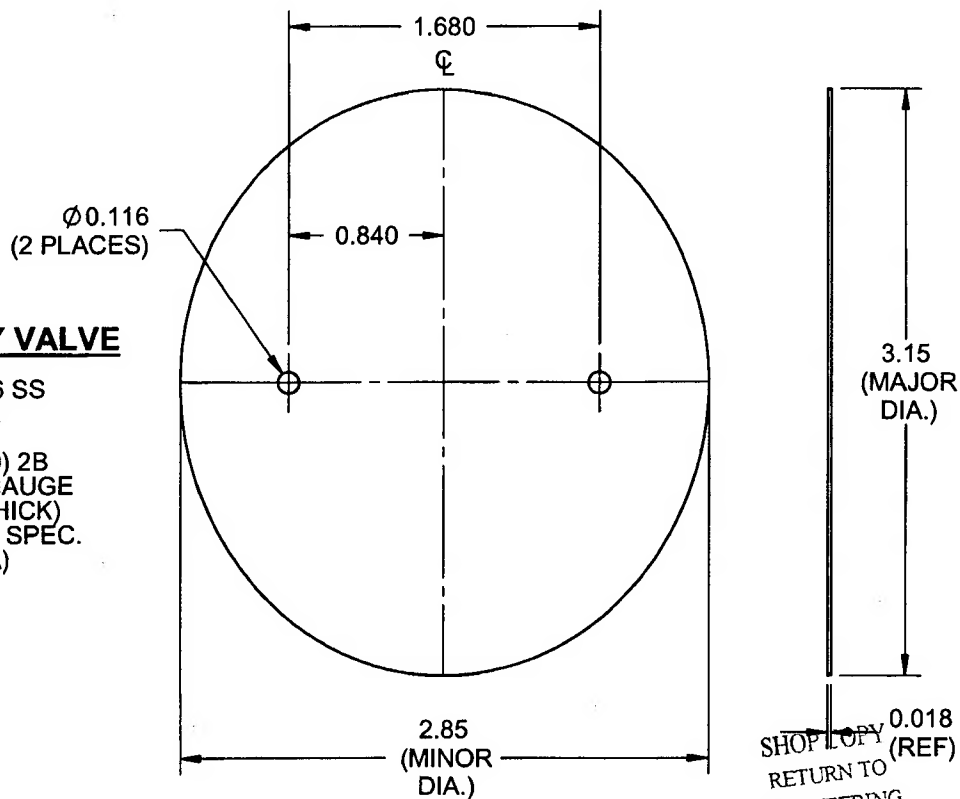
D3470-3 CONTROL ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3470-5 BUTTERFLY VALVE

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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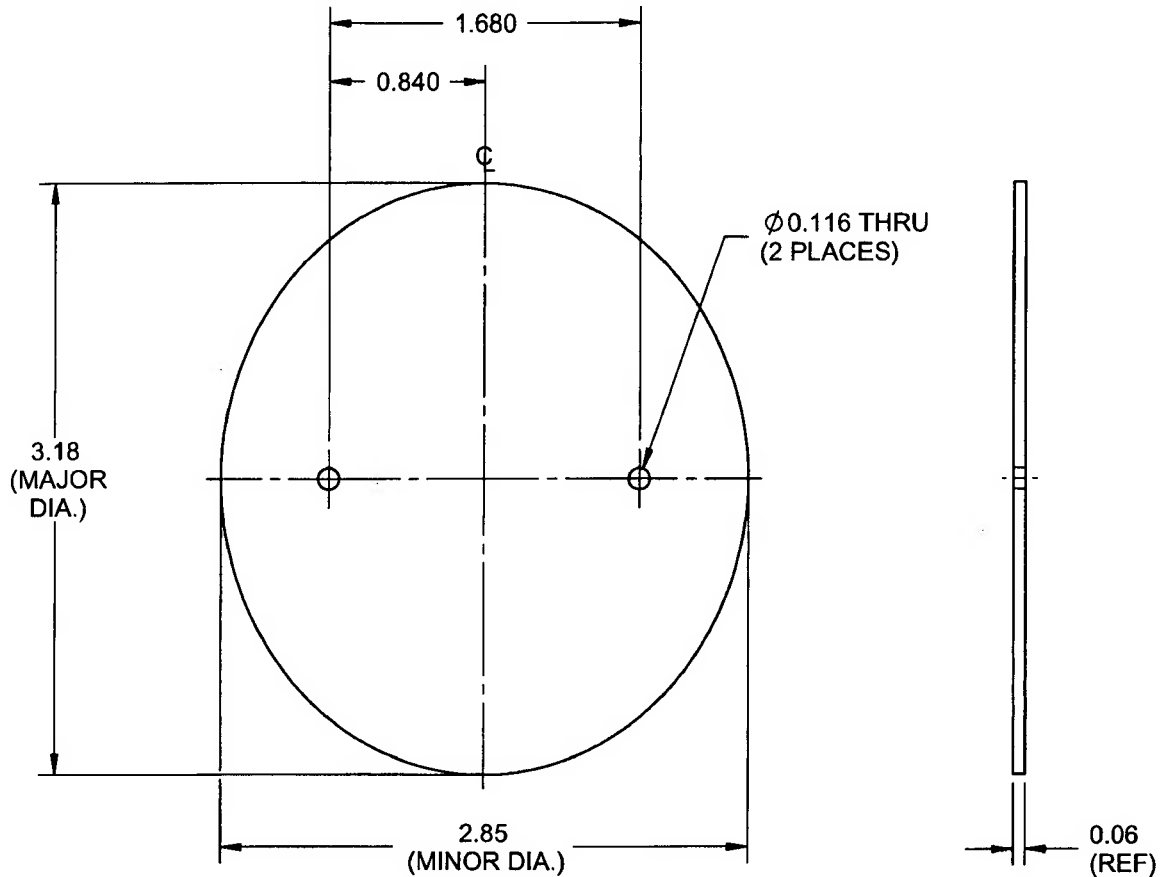
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CHECKED #	APPROVED #	DRAWING NO. D3470	REV. A SHEET 4 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06-04-03 #

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